Dart Aerospace Ltd. Wednesday, 5/23/2007 3:24:08 PM Date: User: **Process Sheet Drawing Name** : MOUNTING ANGLE : CU-DAR001 Dart Helicopters Services Customer Job Number : 32460 **Estimate Number** : 10509 Part Number : D2564 P.O. Number D2564 REV. B1 **Drawing Number** This Issue : N/A Prsht Rev. Project Number : MACHINED PARTS **Drawing Revision** First Issue : 30464 Material Previous Run **Due Date** : 6/8/2007 Qty: 40 Um: Each Written By Checked & Approved By Re-format; Added FA276 Folio KJ/RF : Est:D Comment **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 1.0 D6207 Angle Extrusion 1x1x.125 Comment: Qty.: 0.0962 f(s)/Unit Total: 3.8472 f(s) Angle Extrusion Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8) Batch: B 27538 BAND SAW 2.0 BAND SAW Comment: BAND SAW 07/07/10 Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030) 3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA276 and Dwg D2564 Tumble and Deburr Identify as D2564 INSPECT PARTS AS THEY COME OFF MACHIN 4.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 5.0 QC8 SECOND CHECK

Comment: SECOND CHECK



07/07/12

Dart	Ae	rosp	ace	Ltd
------	----	------	-----	-----

W/O:	-			WORK ORDER	CHANGES						
DATE	STEP	•	PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
										1	
										100	
Part No	:	· · · · · · · · · · · · · · · · · · ·	PAR #:	Fault Category:	NCF				Date: ∰		
		Ι		MODIC ODDED NON CO	NEODMANOE		N/C Close	ed:	Da	ate: _	

NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)					
				Description of NC	Corrective Action Section B Verification		Corrective Action Section B		Annroyal	Annroval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
					:					

NOTE: Date & initial all entries

Date:

Wednesday, 5/23/2007 3:24:08 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 32460

Part Number: D2564

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1 Identify and Stock

Location:

7.0

QC21





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U Statello

Dart Aerospace Ltd

W/O:		WORK ORDER CHAN	IGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•	:				
				;			
Part No	:	PAR #: Fault Category:	NCR: Yes	s No DQ	A:	Date: _	
			QA:	N/C Close	d:	Date:	

NCR:	!	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B Verification Appr		Varification	Annroyal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto	
			,						
				·					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32460
Description: Mounting Angle	Part Number:	D2564
Inspection Dwg: D2564 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.015				
0.625	+/-0.010	-625	/			
Ø0.257	+/-0.010	:258				
1.000	+/-0.010	1.001				
1.000	+/-0.010	1.002	//			
R0.375	+/-0.010	.375				
					**************************************	`
,						
						,
			,			

Measured by:	J.L.	Audited by:	Inl	Prototype Approval:	N/A
Date:	07/01/09	Date:	07/07/09	Date:	N/A

Rev	Date	Change	Revised by	Approx/ed
Α	04.06.10	New Issue	KJ/JLM 🙏	

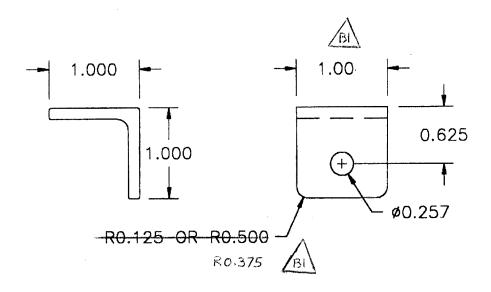
	The state of the s	-
	ver a train de la company de l	. =
		•
	,	
\$		
	¥.	
・ 1000mmの 1000mm 10		





DESIG		DRAWN BY	DART AEROSPACE		
MIKE		APPROVED_	DRAWING NO.	REV.	B
B	W	BW	D2564	SHEET 1 OF	1
DATE			TITLE	SCAL	E
96:0	4:30		MOUNTING ANGLE	1	1:1
В		97:05:06	MODIFIED DIMENSIONS		
	kl _		100 876	_	

96:04:30		MOUNTING ANGLE	1:1
В	97:05:06	MODIFIED DIMENSIONS	
Bi	AF 02.09.17	ROJTS WAS ROIZS OR ROISOD;	



NOTES:

MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125

MAKE FROM DE207-XXX ANGLE EXTRUSION

- 2) BREAK ALL SHARP EDGES 0.005 0 015
- 3) TOLERANCES PER DART ESI DIS UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT